

Date: 3/24/2006 2:25:36 PM
User: [illegible]

Process Sheet

Split

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	ARM
Job Number:	26345 <u>2</u>		
Estimate Number:	10145		
P.O. Number:	NIA	Part Number:	D2037101
This Issue:	3/24/2006 S.O. No.: NIA	Drawing Number:	D2037 REV C3
Project:	NC	Project Number:	N/A
First Issue:	3/23/2006 Type: SMALL/MED FAB	Drawing Revision:	C3
Previous Run:	24160A03	Material:	NIA
Written By:	SEE COMMENT BELOW	Due Date:	3/30/2006
Checked & Approved By:	Jif 06.03.24	Qty:	11 Um: Each
Comments:	Est Rev: A New Issue 05-11-01 JLM		

Additional Product:	
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Job Number:	
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Seq #	Machine Or Operation:	Description:
1.0	M304TR0750W049	304 RD Tube .750 x .049W

Comment: Qty.: 4.1118 f(s)/Unit Total: 41.1180 f(s) M 100 599
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
Batch: 10044312 / m 100540 (K6)

FF 06.04.07 11
T.T. 06.04.03 19

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

FF 06.04.07 11
FF 06.04.03 19

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

FF 06.04.07 11
FF 06.04.03 9
FF 06.04.10 11
FF 06.04.04 9
FF 06.04.12 11
FF 06.04.04 9

4.0	QCS	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

CPL 06.04.13

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26345

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

⑩
06/04/13

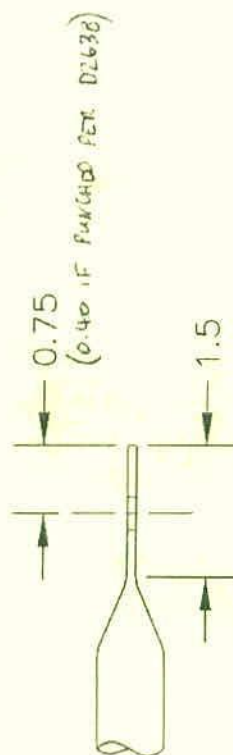
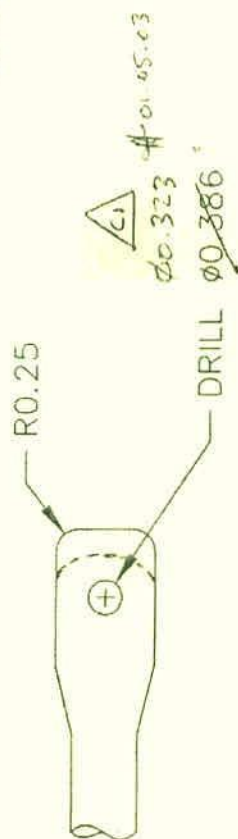
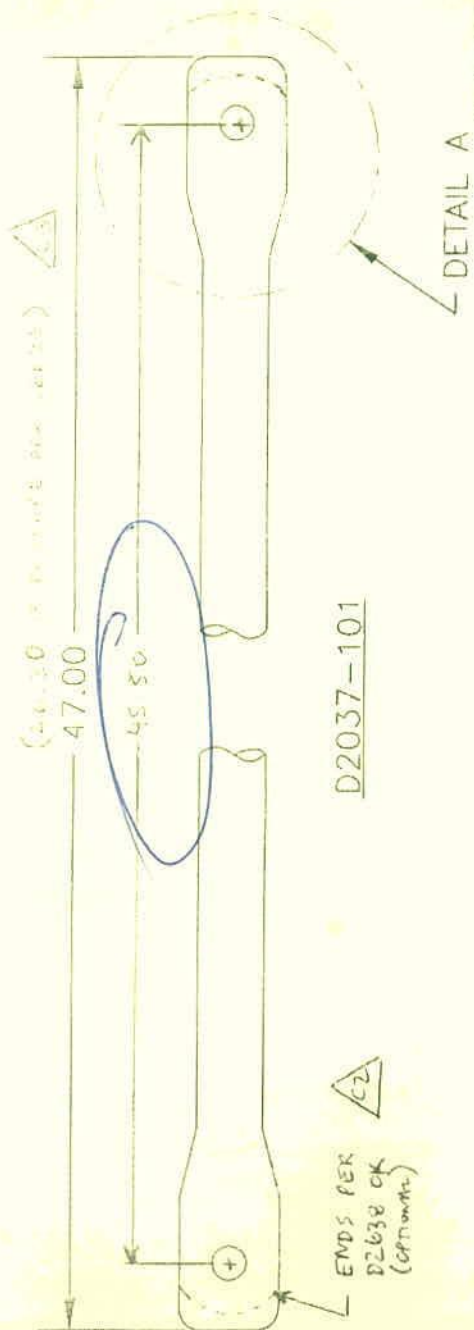
Job Completion:



06-04-13



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07		TITLE ARM	SCALE NTS
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	# CP 01.05.03	CHANGE TO $\phi 0.323$	
C2	# CP 02.06.14	ADD PUNCH PER D2636 AS OPTIM	



RELEASED
KE 99.06.10

DETAIL A

SHOP COPY
RETURN TO
DRAWING ROOM
UNLESS OTHERWISE NOTED
NO JET TO INFLUENCE
WELDING PROCESS
WORK ORDER
26345

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3	# 05.04.27	ADD 46.30 PUNCHED PER D2636
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